

Work Order ID 84426

84426

May-11-12 2:24:05 PM

Page 1

Item ID: D3954-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: GWT Knob

Stop *NS2*

Start Date: 11/05/2012 Start Qty: 10.00

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3954

C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3854

Dwg Rev: E

Prog Rev: C

304 - 375 x 3.00

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20 0 JM 12-5-22

20 0 JM 12-5-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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10

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10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

130

130

Mill Conv

Conventional Milling Machine

Memo

1-OPEN TO TAP DRILL SIZE

2-TAP AS PER DWG D3954

0.00

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Quality Control

Memo

0.00

20

12-05-23

20

12-5-28

20

5/11/12

Dart Aerospace Ltd

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Page 3

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: ST 76 0.00

170

Packaging

Memo

0.00

Packaging

20x

Sp
12-5-29

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/30

MF
12-05-30

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NOTE: Date & initial all entries

Picklist Print

May-11-12 2:24:08 PM

Page 1

Work Order ID: 84426

84426

Parent Item: D3954-3

D3954-3

Parent Item Name: GWT Knob

Start Date: 11/05/2012

Required Date: 25/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.375X03.000		Purchased	No			100	f	31.7400	0.02778	0.292421			

M304B0 375X03 000

**

M304 SS bar .375 x 3.00

Location

Loc Qty

Loc Code

MAT050

31.74

118523

5.74

119654

4.8

120204

21.2

120204

JM
12-5-22

Dart Aerospace Ltd

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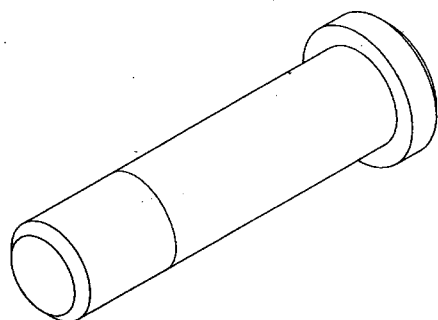
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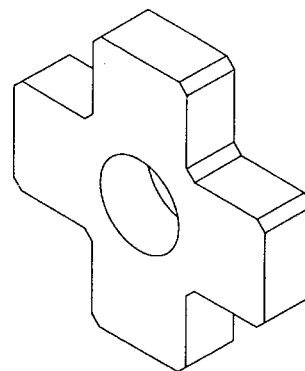
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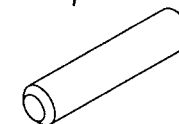


D3954-1 GWT PIN

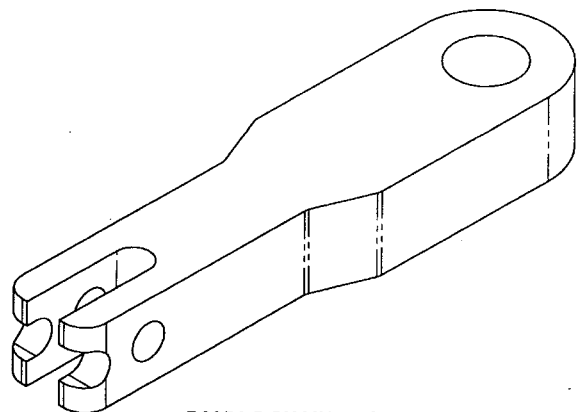


D3954-3 GWT KNOB

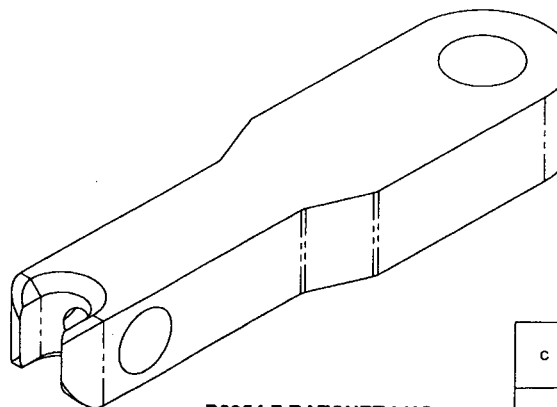
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24426 MLJ
12/05/11



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

RELEASED
2011-07-29

C	MATERIAL UPDATE FOR D3954-1/3: NOW STAINLESS STEEL ONLY (A8-2); FINISH CHANGED TO "NONE" FOR D3954-1/3 (A8-2); TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3); D3954-9 NOW A PURCHASED PART (A2/A6-3). REASON: PAR11-113.	MB	11.07.27
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS/DSTOW		
DRAWN			
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	11.07.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3954** REV. C
SHEET 1 OF 3
TITLE **MISC MACHINED PARTS GWT KIT** SCALE **NTS**

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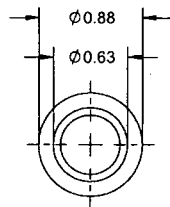
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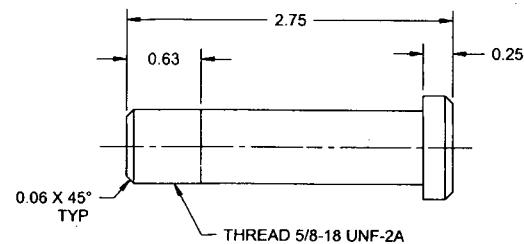
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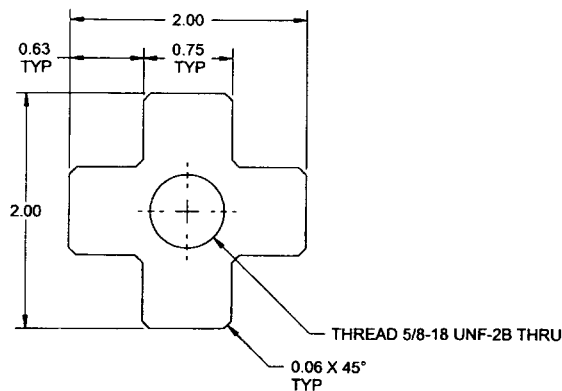
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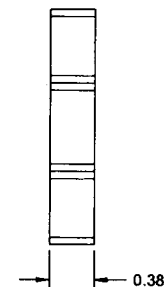
D3954-1 GWT PIN



84426



D3954-3 GWT KNOB



NOTES:

- 1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R
-3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S
OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2011-07-29

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3954	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	11.07.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

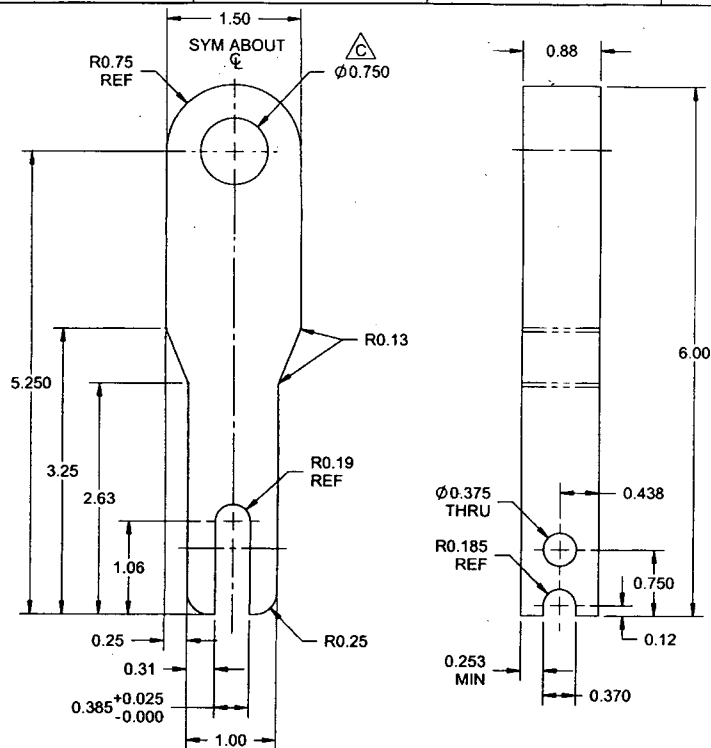
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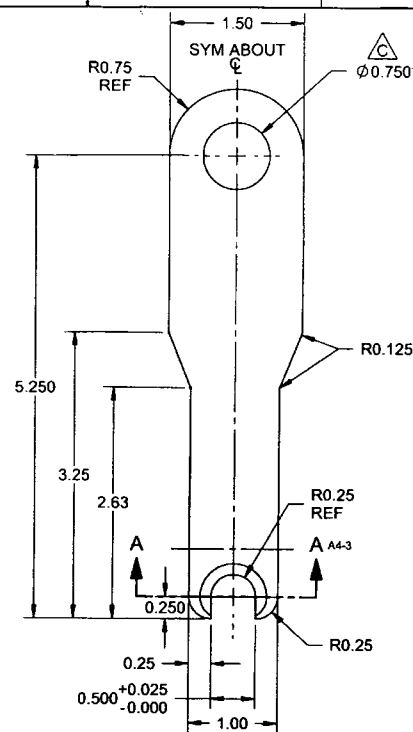
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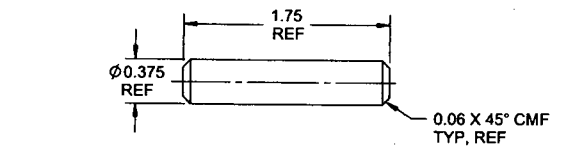
NOTE: Date & initial all entries



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



D3954-9 GWT CHAIN PIN

NOTES:

1) MATERIAL:

-5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 98381A630 (MILD STEEL)

ALTERNATE MATERIAL:

-5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 90145A630 (STAINLESS STEEL)

2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

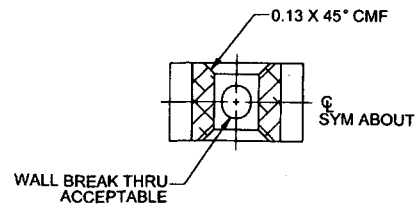
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs REF



SECTION A-A C3-3

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D3954	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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